

Date: Thursday, 11/29/2007 11:08:34 AM
 User: Kim Johnston

Process Sheet

52

| | | | |
|-----------------------|---|------------------|---------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : 206L FWD X-TUBE |
| Job Number | : 36052 | | |
| Estimate Number | : 10553 | | |
| P.O. Number | : <u>N/A</u> | Part Number | : D206667103 |
| This Issue | : 11/29/2007 S.O. No. : <u>NA</u> | Drawing Number | : D206-667-143 REVB |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <u>N/A</u> Type : LANDING GEAR | Drawing Revision | : B |
| Previous Run | : 35305 | Material | : <u>N/A</u> |
| Written By | : <u>JA 07/11/29</u> | Due Date | : 12/24/2007 |
| Checked & Approved By | : <u>JA 07/11/29</u> | Qty: | 1 Um: Each |
| Comment | : Est Rev: 05.09.01 Add holes for compatibility with Bell Skidtubes KJJ/JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

1.0

DC

DOCUMENT CONTROL



RS 07.12.07

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG002

08/06/16

2.0

D6002115

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6002-115 Crosstube B23966

Check OD = 2.250"; ID = 1.750"

J.F. / 8F 07/12/09

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087

2-Turn first side as per Folio FA087

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

J.F. / 18F 07/12/09

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/12/11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:08:34 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36052

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA087

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143

Inside of Cuff(Donot engrave on outside of tube)

J.F. 07/12/11 (1)

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/12/11 (1)

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L. 07/12/11

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

AWM 07-12-13

1-Polish entire outside surface of crosstube

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DD 7-12-13

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM 07-12-13

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 206L-fw and Folio FT017

EL 7-12-13

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36052

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



7-12-13 (1)



Comment: DIMENSIONAL CHECK OF X-TUBES

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-143.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

*SR
7-12-13*

*AWM
07-12-14*

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



*AWM
07-12-14*



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5 08/01/04 (40)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/01/04 (40)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36052

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 5362 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

CL 8/01/04 (1)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

CL 8/01/04 (1)

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

CL 08/01/04 (1)

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

RT 08-01-08

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

RT 08-01-09 (1)

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 6.94") Abrasion Strip

35900

RT 08-01-09

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate

33422

RT

08-01-08

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36052

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate 34077

ZT 08-01-08

25.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1 Support 34062

ZT 08-01-09

26.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet 105057

ZT 08-01-08

27.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20 Clamp 103478

ZT 08-01-09

28.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. .Note: (2) Aft holes should be facing up.

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

ZT 08-01-09

ZT 08-01-08

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36052

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 08/01/16 (X)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M105405

AS 08/01/16 (X)

32.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M105940

AS 08/01/16 (X)

33.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-7A

Bolt M106167

AS 08/01/16 (X)

34.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-30A

Bolt M103641 x3 M105144 x1

AS 08/01/16 (X)

35.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer M104156 6X

AS 08/01/16 (X)

M106167 x12

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 08/01/17
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:08:35 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36052

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

U 08/01/16 (40)

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location: B

PPP Rev: 8/1/16

SD (12)

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

U 08/01/17 (1)

Job Completion



U 08/01/17

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

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|--|----------------------------------|
| DART AEROSPACE LTD | Work Order: 36052 |
| Description: Crosstube Assembly (206L High Fwd) | Part Number: D206-667-143 |
| Inspection Dwg: D206-667-143 Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

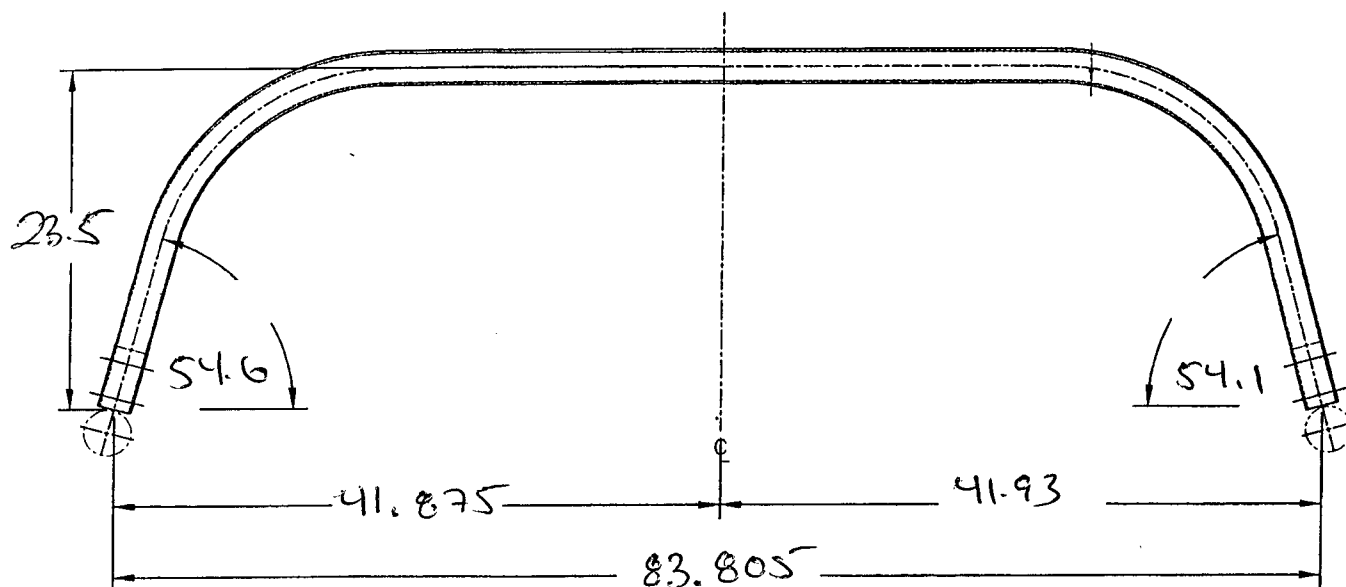
| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|-------------|---------------------|------------|--------|-------------------------|----------|
| SIDE A | 2.240 | +0.005/-0.000 | 2.244" | ✓ | | |
| | 1.982 | +0.005/-0.000 | 1.986" | ✓ | | |
| | 2.019 | +0.005/-0.000 | 2.024" | ✓ | | |
| | 2.058 | +0.005/-0.000 | 2.063" | ✓ | | |
| | 2.097 | +0.005/-0.000 | 2.101" | ✓ | | |
| | 2.136 | +0.005/-0.000 | 2.138" | ✓ | | |
| | 2.176 | +0.005/-0.000 | 2.180 | ✓ | | |
| | 2.201 | +0.005/-0.000 | 2.205 | ✓ | | |
| | | | | | | |
| | 0.125 | +/-0.010 | .125 | ✓ | | |
| | 0.400 x 30° | +/-0.010 | .400 x 30° | ✓ | | |
| | R0.063 | +/-0.010 | R0.063" | ✓ | | |
| | R0.500 | +/-0.010 | R0.500" | ✓ | | |
| | 4.438 | +/-0.030 | 4.441" | ✓ | | |
| SIDE B | 104.98 | +/-0.020 | 104.98 | ✓ | | |
| | 2.240 | +0.005/-0.000 | 2.244" | ✓ | | |
| | 1.982 | +0.005/-0.000 | 1.986" | ✓ | | |
| | 2.019 | +0.005/-0.000 | 2.024" | ✓ | | |
| | 2.058 | +0.005/-0.000 | 2.063" | ✓ | | |
| | 2.097 | +0.005/-0.000 | 2.101" | ✓ | | |
| | 2.136 | +0.005/-0.000 | 2.139" | ✓ | | |
| | 2.176 | +0.005/-0.000 | 2.179" | ✓ | | |
| | 2.201 | +0.005/-0.000 | 2.203" | ✓ | | |
| | | | | | | |
| | 0.125 | +/-0.010 | .125 | ✓ | | |
| | 0.400 x 30° | +/-0.010 | .400 x 30° | ✓ | | |
| | R0.063 | +/-0.010 | R0.063" | ✓ | | |
| | R0.500 | +/-0.010 | R0.500" | ✓ | | |
| | 4.438 | +/-0.030 | 4.447" | ✓ | | |

| | | | |
|-------------------------------|-------------------------|----------------------------|-----|
| Measured by: S.F./J.F. | Audited by: J.L. | Prototype Approval: | N/A |
| Date: 07/12/69 | Date: 07/12/11 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A | 04.05.06 | New Issue (P/O D206-667-103) | KJ/RF | |
| B | 06.03.09 | Dwg Rev updated | KJ/JLM | |

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|--|--|--------------|--------------|
| DART AEROSPACE LTD | | Work Order: | 36052 |
| Description: Crosstube High Fwd (206L) | | Part Number: | D206-667-103 |
| Inspection Dwg: D206-667-143 Rev: B | | Page 1 of 1 | |

| Required Dimension | Min | Max |
|--------------------|-------|-------|
| Height | 23.46 | 23.58 |
| 1/2 Span | 41.86 | 41.98 |
| Angle | 54 | 56 |
| Total Span | 83.72 | 83.96 |



| Comments |
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| QC15 Inspection | 27.12.13 |
| Date | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|--------------------|
| A | 07.02.06 | New Issue | KJ/JM | <i>[Signature]</i> |

DART

| | | | |
|------------------|-----------------|---|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED HDS | APPROVED HDS | DRAWING NO. D206-667-143 | REV. B SHEET 1 OF 3 |
| DATE 05.07.26 | | TITLE CROSSTUBE ASS'Y (206L HIGH FWD) | SCALE NTS |
| A | 00.11.17 | NEW ISSUE | |
| B | 05.07.26 | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES | |

RELEASED
05-07-26 H**UNDER REVIEW**

05-07-10 PH

re-draw detail F
PH

07.05.02

| Qty | Part Number | Description |
|-----|---------------|------------------------------------|
| X | D206-667-143 | CROSSTUBE ASSEMBLY (206L HIGH FWD) |
| 1 | D6002-115 | CROSSTUBE |
| 2 | D2873-043 | NUT PLATE |
| 2 | D2873-045 | NUT PLATE |
| 2 | D2856-400-694 | ABRASION STRIP |
| 2 | D2891-1 | SUPPORT |
| 14 | MS20601AD4W8 | RIVET (OR NAS9302B-4-8) |
| 4 | MS21920-20 | CLAMP |

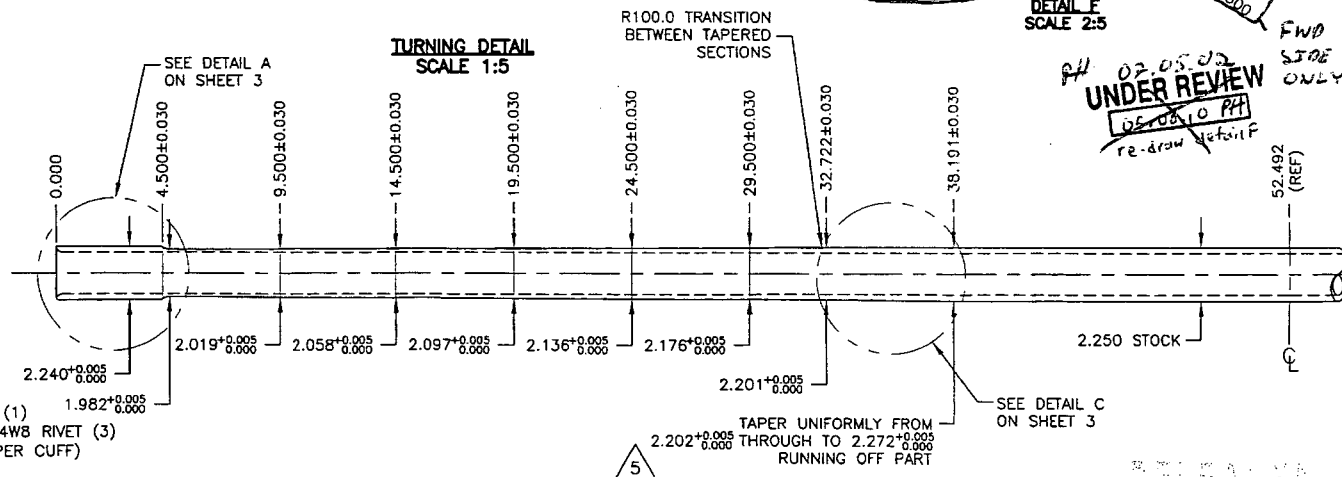
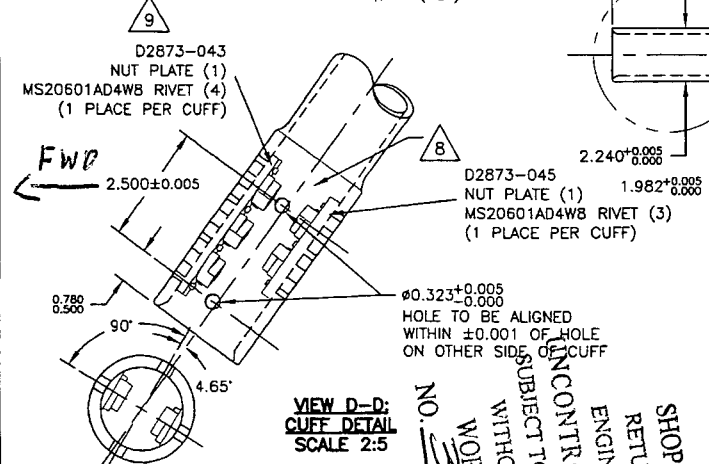
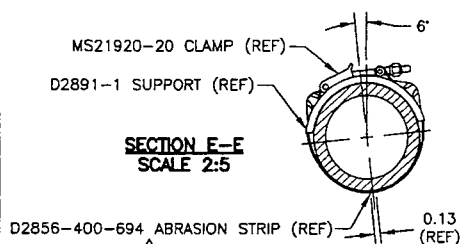
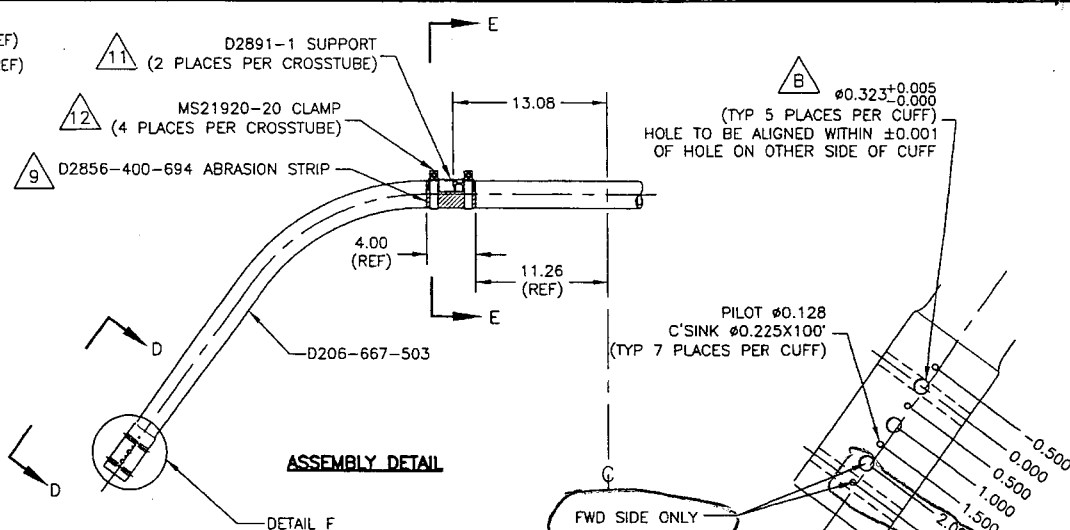
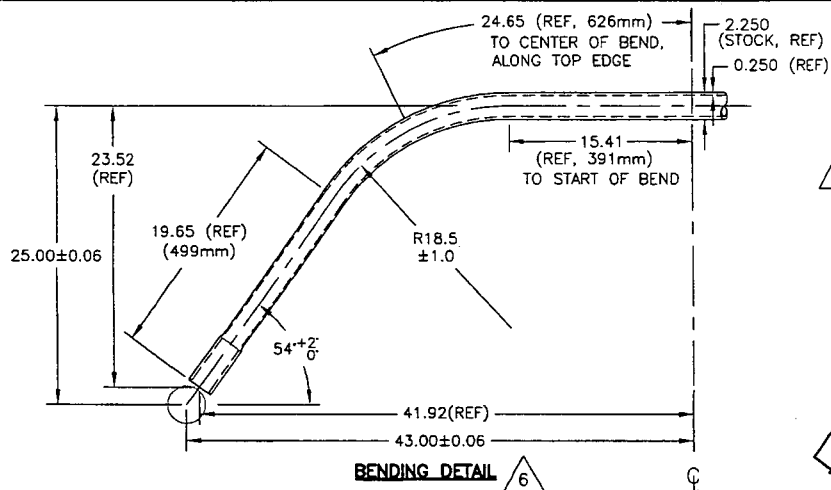
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX 241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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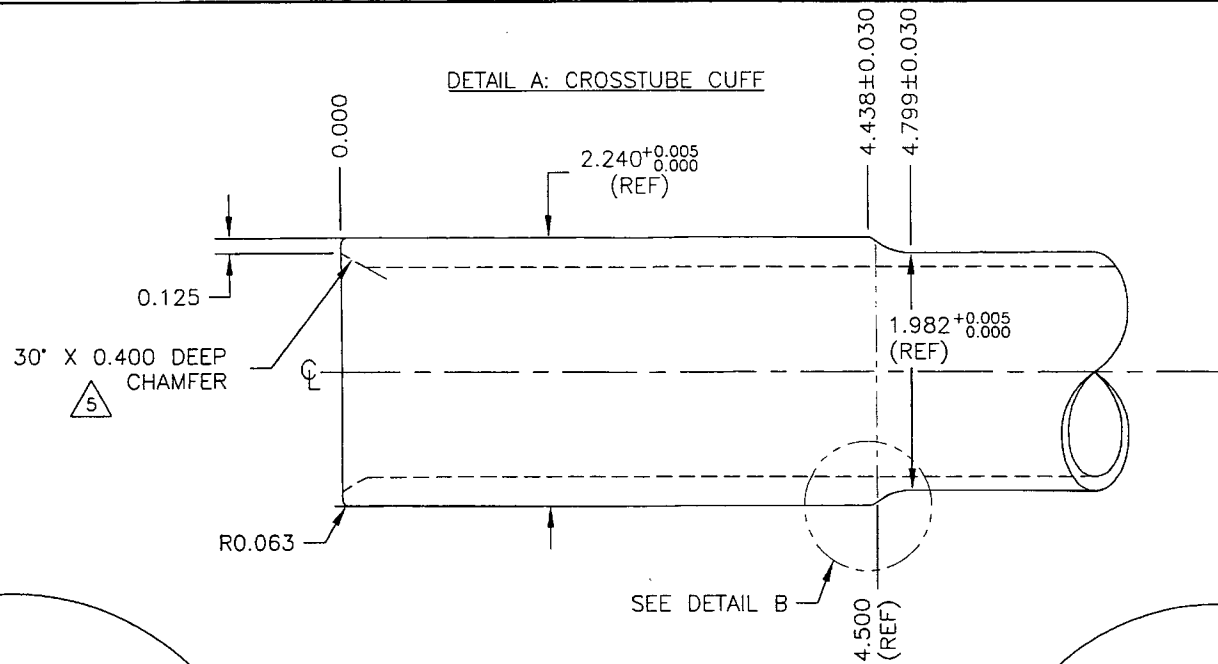
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UNDER REVIEW
05.08.10 PH
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05-07-26

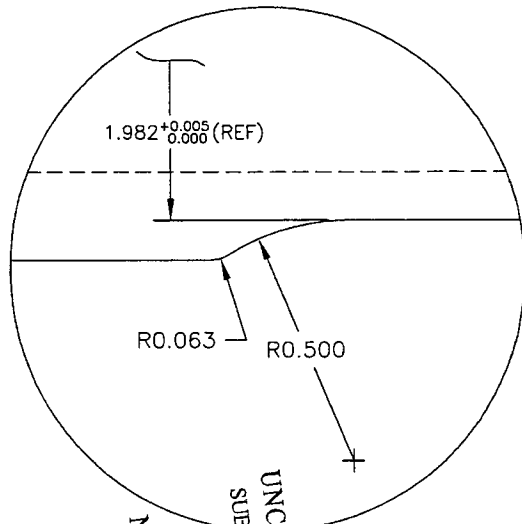
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| | CHECKED PH | APPROVED PH | | |
| | DATE 05.07.26 | TITLE CROSSTUBE ASS'Y (206L HIGH FWD) | | SCALE 1:10 |
| | | | | |

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DETAIL A: CROSSTUBE CUFF

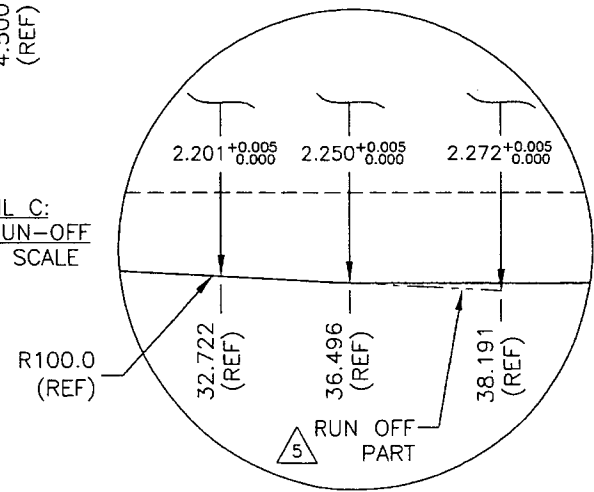


05.07.26 PH
~~PH 07.05.02~~
 UNDER REVIEW
 PH 07.05.02



DETAIL B: CUFF
 TRANSITION
 SCALE 4:1

DETAIL C:
 TAPER RUN-OFF
 NOT TO SCALE



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| CHECKED HDS | | APPROVED HDS | | TITLE CROSSTUBE ASS'Y (206L HIGH FWD) | SCALE 1:1 |
| DATE 05.07.26 | | | | | |



LIQUID PENETRANT TEST REPORT

P - 8-1202

| | | | | | | | |
|------------------|---|-----------------|-------------------|-----------|-----------------------------|-----------------------------|---|
| CLIENT | DART AREOSPACE | DATE | JAN. 4, 2008 | PAGE | 1 | OF | 1 |
| ATTENTION | LINDA LACELLE | ACUREN JOB No. | 188-8-01202 | TIME | AM <input type="checkbox"/> | PM <input type="checkbox"/> | |
| ADDRESS | 1270 ABERDEEN ST. HAWKESBURY ONT. | PO/VO No. | | | | | |
| | | WORK LOCATION | HAWKESBURY | | | | |
| | | ACCEPTANCE STD. | ASTM 1417/QSI-038 | REV./DATE | 2005 | | |
| PROJECT | 206B AFT X-TUBE, 206L FWD X-TUBE, HIGH AFT X-TUBE 412 | | | | | | |
| ITEM(S) EXAMINED | JOB#S 36051, 36052, 36054, 36060, 36063 | | | | | | |

| | | |
|-----------------|--|--------------------------------------|
| JOB DESCRIPTION | PROCEDURE No. LT-0002 REV./DATE | TECHNIQUE No. LT-0002-02 REV./DATE |
| Part No. | D206667201, D206667103, D412664203 | Material ALODYNED ALUMINUM Thickness |
| Scope | WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% OF EXTERNAL SURFACE. | |

TEST DETAILS

| | | | | | |
|-------------------|---|----------------------------------|--|---|--|
| Method | <input checked="" type="checkbox"/> Fluorescent | <input type="checkbox"/> Visible | <input checked="" type="checkbox"/> Water Wash | <input type="checkbox"/> Solvent Removable | <input type="checkbox"/> Post Emulsified |
| Family Brand | MAGNAFLUX | | Black Light S/N 8178 | <input checked="" type="checkbox"/> Output > 1000 μ W/cm ² | <input checked="" type="checkbox"/> Ambient < 2 fc |
| Penetrant | ZL67 | Minimum Dwell time 45 Min. | Lighting Equip. <input checked="" type="checkbox"/> Flashlight <input type="checkbox"/> Troublelight | <input checked="" type="checkbox"/> Output > 100 fc @ surface | |
| Penetrant Remover | H20 | Minimum Dry time > 10 Min. | Other | | |
| Developer | SKDS2 | Minimum Dwell time 10 Min. | Light Meter S/N | Cal Due Date | MAR 08 |
| Developer Type | <input checked="" type="checkbox"/> Non Aqueous <input type="checkbox"/> Aqueous <input type="checkbox"/> Dry | | | | |

TEST SURFACE

| | | | | | |
|---------------------|---|---|---|---------------------------------------|---|
| Surface Condition | <input checked="" type="checkbox"/> As Ground | <input type="checkbox"/> As Welded | <input checked="" type="checkbox"/> Machined | <input type="checkbox"/> Shot Blasted | <input type="checkbox"/> Clean Bare Metal |
| Surface Temperature | <input type="checkbox"/> < - 4°C/ 20°F | <input type="checkbox"/> - 4°C/ 20°F to 10°C/50°F | <input checked="" type="checkbox"/> 10°C/50°F to 52°C/125°F | <input type="checkbox"/> > 52°C/125°F | |

RESULTS- (☐ METRIC ☐ IMPERIAL)

| item | Comments | Accept | Reject |
|-------|-------------------|--------|--------|
| Job # | 36051: ACCEPTABLE | | |
| | 36052: ACCEPTABLE | | |
| | 36054: ACCEPTABLE | | |
| | 36060: ACCEPTABLE | | |
| | 36063: ACCEPTABLE | | |

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

| | | | |
|-------------------------|----------------------------|---------------------|--------------|
| Client Representative | | DTR # | |
| Technician (Signature): | | Report Reviewed by: | |
| Name (Print): | FREDERICK CHAGNON | Name initials | |
| | 1 st technician | | |
| CGSB Level | II SNT Level | CGSB Level | II SNT Level |
| CGSB Reg. No | 10560 | CGSB Reg. No | 12247 |

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